

5/14

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22636
<b>Description: Top</b>	<b>Part Number:</b>	D3249-1
<b>Dwg: D3249 Rev. A</b> <i>BA 11.12</i>	<b>Qty:</b>	10
		Page 1 of 1

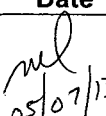
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>ML</i>	05.03.09	10
2	PG	Issue P/O: <u>207692</u> Fabricate D3249-1 as per Dwg D3249 Possible Supplier: Industrial Laser <b>Material release note is required</b>	<i>LC</i>	05.03.10	10
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	<i>CL</i>	05/06/08	10
4	QC6	Inspect dimensions as per Dwg D3249	<i>ml</i>	05/07/13	10
5	GA	Deburr	<i>ml</i>	05/07/13	10
6	QC5	Inspect work to Step 5	<i>2</i>	05.08.03	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>FF</i>	05.08.04	10
8	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	<i>FC</i>	05.08.09	10
9	QC3	Inspect Powder Coat	<i>ML</i>	05.09.10	10
10	ST	Identify and Stock	<i>CL</i>	05/08/11	10
11	AC	Cost / part			
12	DC	Close W/O Inspect Level 21			

PTO

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	
B	04.10.26	D3249-1 no longer made in-house	KJ/JLM	<i>[Signature]</i>

RELEASED  
*[Signature]* 04-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/13	4	dimension are good except $\phi$ of 49 holes should be $\phi .098$ was $0.090$ Some pieces are dirty		open Holes $\phi .098$ (49 pls) as drawing $\phi .3349$ Smooth Buffing on each part. (as other Parts)	 05/07/13			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

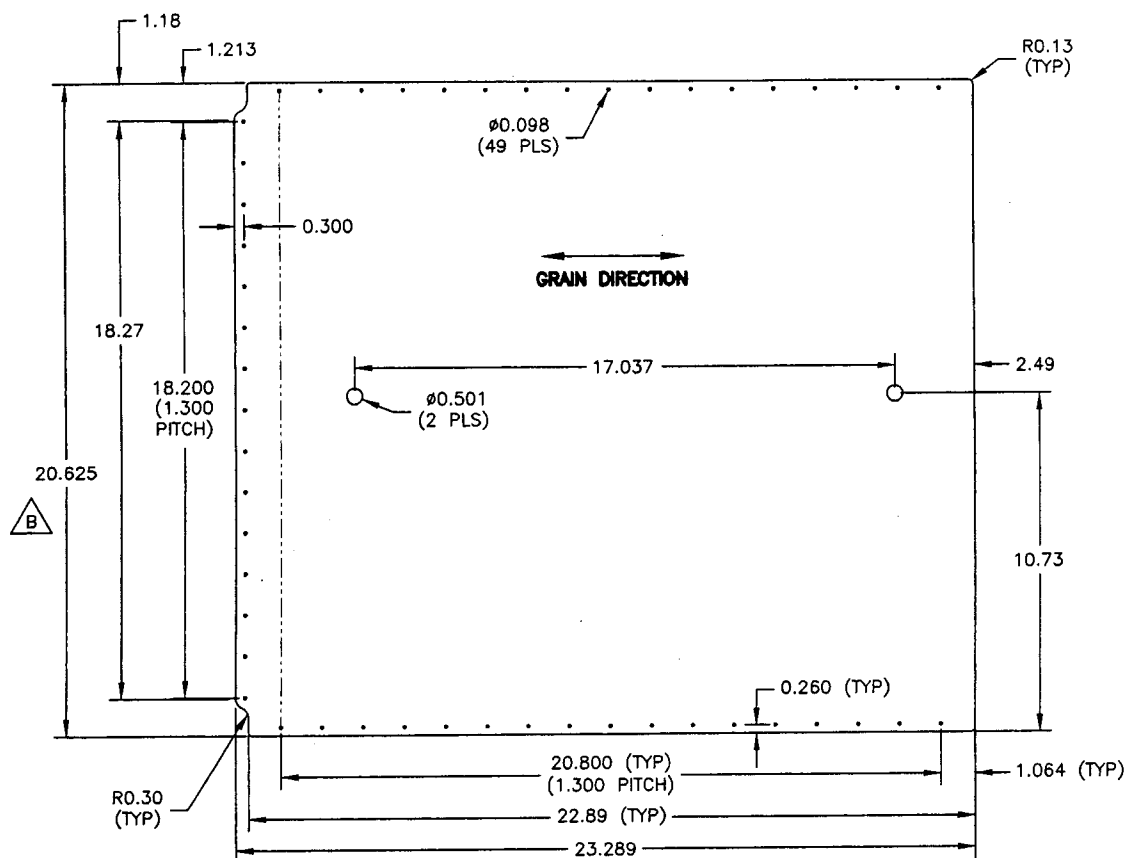
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

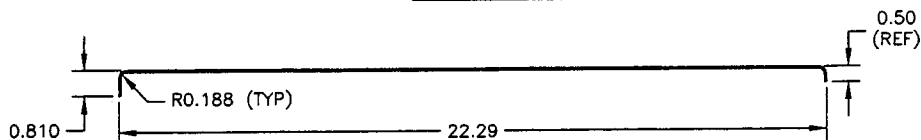


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3249	REV. B SHEET 1 OF 1
DATE 04.11.04		TITLE TOP (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.245	

RELEASED  
04.11.04



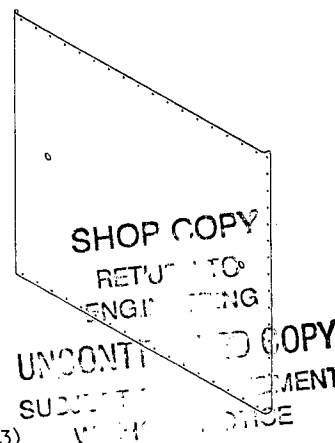
FLAT PATTERN



D3249-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



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# PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS  
4700 COLORADO AVENUE  
SEATTLE WA

98124

ALASKAN

T86002 4330

## CERTIFIED TEST REPORT

PECHINEY ROLLED PRODUCTS

ALASKAN COPPER & BRASS  
P.O. BOX 3546  
SEATTLE WA

98124

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CUSTOMER PURCHASE ORDER NO. & ITEM <b>16497</b>				PECHINEY ORDER NO. <b>052-880417</b>		<b>CERTIFICATION</b> "Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."  <b>PECHINEY ROLLED PRODUCTS</b> RAVENSWOOD, WV 26164  <i>Mark E. Parsons</i> MARK E. PARSONS-LABORATORY SUPERVISOR
ALLOY <b>5052</b>	CLAD. <b>00</b>	TEMPER <b>H32</b>	GAUGE <b>.06300</b>	WIDTH <b>48.000</b>	LENGTH <b>.000</b>	
ITEM ORDERED <b>RAVENSWOOD DISTRIBUTOR SPEC COIL NON HT MILL</b>						
CUSTOMER SPECIFICATION <b>AMS-QQ-A-250/8</b>						
PART NUMBER			B/L NUMBER <b>T86000</b>		DATE SHIPPED <b>04-09-03</b>	
WEIGHT SHIPPED <b>13,345</b>		NO. OF PIECES <b>1</b>		GOVT. CONTRACT NO.		

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		MIN	MAX									
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.											
449461			ACTUAL CHEMICAL COMPOSITION																
			SI=0.10 FE=0.27 CU=0.07 MN=0.05 MG= 2.4 CR=0.18 ZN=0.02 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																
C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

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1

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PECHINEY ROLLED PRODUCTS  
RAVENSWOOD, WV 26164

*Mark E. Parsons*

MARK E. PARSONS-LABORATORY SUPERVISOR

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			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.										
449461	L	2	33.8	33.8	27.6	27.6	9.3	10.9	.0	.0								
ALSO CONFORMS TO ASTM B209																		
<div>ALASKAN COPPER &amp; BRASS CO APPROVED BY:  DATE: 4/16/03 P.O.: 16497</div>																		
ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
	SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																		